

Work Order ID 131635***131635***

Page 1

Monday, April 20, 2015 1:22:47 PM

Item ID: D3368-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Tail Rotor Pedal Lock

Start Date: 4/20/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/27/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: ME Date: 5-4-20

Tooling:

Date:

Run Start

NR1

QC: Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2690	B2								
D3368	B								
D3384	C								

100

0.00

100

Small Fab

Small Fab

Memo

0.00

Small Fab

1-Open D3373-7 lock package. Keep keys, lock body, lock body nut, screw, flat cam and lock barrel. Discard the rest.

2-Fabricate D3371-5 Cam Lock as per Dwg D3371

3- Cut cable to length as per dwg D2690 and D3384

4- Assemble lanyard to cyclic sock as per Dwg D3384
Identify as D3384-047

Identify as D3371-53-Assemble lock mechanism and cam and install decal as per Dwg D3368.

UNALIK

1

FF

APR 21 2015

P.T.O.

DQA: det Date: 15/06/16

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: 22/11 Date: 15/06/11Work Order update only ☐

Work Order: <u>131635</u> Part No. <u>3368-04</u> NCR No. <u>15-5089</u>	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☒</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☒	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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Date : <u>15.05.11</u>	Step #: <u>100</u>	QTY Effective : <u>①</u>	MRB (QS1042) Approval DAS 12 9-89 <u>15/4/21</u>																																																																	
Description Work Order Deviation		Disposition		Completed By DAS 30 9-89 <u>APR 21 2015</u> Lead hand / Supervisor Approval Verification DAS 30 9-89 <u>APR 21 2015</u> QC / QA Coordinator Approval DAS 9 9-89 <u>15.04.21</u>																																																																
<u>Red To make hinge to match the part</u> <u>MS00257 C4 7200</u> <u>M129246</u> <u>(REPLACEMENT)</u> <u>l.c. tooling.</u>		<u>Acceptable.</u> <u>Non-airworthy part. Hinge is appropriate to function</u>																																																																		
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Work Order ID 131635

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131635

Page 2

Item ID: D3368-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Tail Rotor Pedal Lock

Stop

NS2

Start Date: 4/20/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/27/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

DAS

38

9-89

APR 21 2015

120

Identify as per dwg & Stock Location

0.00

120

Packaging

Memo

0.00

Packaging

DAS

27

5-89

APR 22 2015

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

MCJ 15-04-23

4-4-22

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
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Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Page 1

Work Order ID: 131635

131635

Parent Item: D3368-041

D3368-041

Parent Item Name: Tail Rotor Pedal Lock

Start Date: 4/20/2015

Required Date: 4/27/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A Removed from 9 Digit 06-03-22 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
238-028 *238-028* 3/16" Dowel Pin .5" long		Purchased	No			100	Each	111.0000	2	2		APR 21 2015	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST568		111							
				108114		11							
				<u>M132062</u>		100				2			
385-039 *385-039* 8-32 Flat screw		Purchased	No			100	Each	100.0000	4	4		APR 21 2015	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST570		100							
				<u>M130688</u>		100				4			
CBL-1240 *CBL-1240* Cable		Purchased	No			100	f	164.1606	2.3333	3		APR 21 2015	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		164.1606				3			
				<u>m130006</u>		164.1606							
CBL-460 *CBL-460* Loop Sleeve		Purchased	No			100	Each	444.0000	2	2		APR 21 2015	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		444							
				<u>m131619</u>		444				2			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Work Order ID: 131635

131635

Parent Item: D3368-041

D3368-041

Parent Item Name: Tail Rotor Pedal Lock

Start Date: 4/20/2015

Required Date: 4/27/2015

Start Qty: 1.00

Required Qty: 1.00

D2728-7

Manufactured No

100

Each

0.0000

0

0

D2728-7

**

Dart Logo Label

D3368-1

Manufactured No

100

Each

4.0000

1

1

D3368-1

**

Pedal Lock Base

Ag 105

FF APR 21 2015

LocationLoc QtyLoc Code

ST496

4

115046

4

D3368-3

Manufactured No

100

Each

3.0000

1

1

D3368-3

**

Pedal Lock Cover

FF APR 21 2015

LocationLoc QtyLoc Code

ST497

3

119439

3

D3373-7

Manufactured No

100

Each

15.0000

1

1

D3373-7

**

Cam Lock

FF APR 21 2015

LocationLoc QtyLoc Code

ST036

15

123528

4

94791

11

D3384-1

Manufactured No

100

Each

2.0000

1

1

D3384-1

**

Cyclic Sock

FF APR 21 2015

LocationLoc QtyLoc Code

ST500

2

123313

2

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Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Past Expiry Date ☐	Manufacturing Process ☐	OTHER :																							
Misidentified ☐	Past Due ☐																								

Picklist Print

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Work Order ID: 131635

131635

Parent Item: D3368-041

D3368-041

Parent Item Name: Tail Rotor Pedal Lock

Start Date: 4/20/2015

Required Date: 4/27/2015

Start Qty: 1.00

Required Qty: 1.00

D3385-3 Manufactured No

100 Each 30.0000 1 1

D3385-3

Hinge

FF APR 21 2015

Location

Loc Qty

Loc Code

ST036

30

117534

30

HX-81 Purchased No

100 Each 72.0000 1 1

HX-81

1/4"-20 SHCS 3/8" long

FF APR 21 2015

Location

Loc Qty

Loc Code

ST554

72

123436

72

NAS1149F0463P Purchased No

100 Each 1,289.000 2 2

NAS1149F0463P

Washer

FF APR 21 2015

Location

Loc Qty

Loc Code

ST260a

986

m127832

986

st268

303

m127832

295

m130388

8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					